

Date: Tuesday, 5/23/2006 8:31:25 AM  
 User: Kim Johnston

## Process Sheet

*Split* 06/05/25

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET  
 Job Number : 27188  
 Estimate Number : 10364  
 P.O. Number : *NIA*  
 This Issue : 5/23/2006 S.O. No. : *NIA*  
 Prsht Rev. : NC  
 First Issue : *NIA* Type : SMALL /MED FAB  
 Previous Run : 25924  
 Written By : *SEE COMMENT BELOW*  
 Checked & Approved By : *06.05.23*  
 Comment : Est: A 01.08.27 New issue SM/EC

Part Number : D3046041  
 Drawing Number : D3046 REV. A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : *NIA*  
 Due Date : 6/2/2006 Qty: *4* Um: *16* Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	<i>B 24715</i>

*SB 06/05/25*

2.0 D30463 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 ( Bell P/N: 206-052-106-1)	Lug Bracket	<i>B 26224</i>

Return Authorization #

Bell original batch#

*③*  
*N/A*

*487*  
*See w/o*

*① B 27197*

*SB 06/05/25*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

*SB 06/05/25*

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*N/A* *06.05.25*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

N/A Jm 05-25

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 160.0000 Each(s)

Rivet

Qty Part Number

Description

Batch

10 MS20426AD5-7

Rivet

M 3676

SB

06/05/25

(4)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB 06/05/25

(4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/05/25

(4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/05/26

(4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/05/26

(4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/05/26



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*PP* 06/05/26 (4)

Job Completion

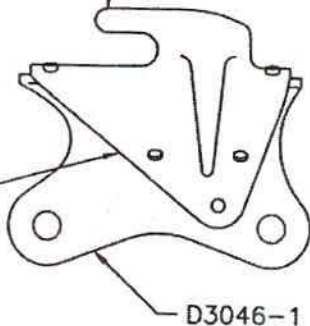


*C 206105126*

**DART**

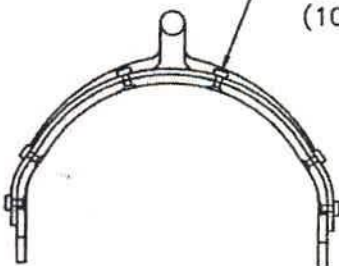
DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		REV. A	
01.08.23		LUG BRACKET		SHEET 1 OF 2	
A		NEW ISSUE		SCALE	
				1:2	

D3046-3  
(BELL P/N 206-052-106-1)



CENTER D3046-3  
ON D3046-1

TRANSFER DRILL  $\varnothing 0.156$  HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\varnothing 0.286 \times 100^\circ$   
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.  
REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.
- STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27188

RELEASED  
01.08.23

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